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# Work Order ID 62689

Wednesday, October 06, 2010 3:20:04 PM



Page 1

Revision ID:	D4070-041 Clamp	<b>\</b>		Accept				s	etup Star Stoj	1 (88/119) 2	
	10/6/2010	Start Qty: 40.00 Req'd Qty: 40.00	1 1 2 2 1 2 2 1 2 2 2 2 2 2 2 2 2 2 2 2	181	Cust Item I Customer:	D:				1 1881   E	1 <b>919</b> 116 1161 1661
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:	- ·	R	tun Star Stop		######################################
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4070	Rev A	rision Nbr									
Waterjet FLOW CNC Waterje		Memo Cut as per Prog rev:_ dwg rev:_	<i>P</i> 3	0.00				<u>B</u> (	0-10-7		
QC Quality Control		QC2- Inspect parts off  Memo	machine FAI/FAIB	0.00				IB 10	u-10-7		
120 QC Quality Control		QC8- Inspect parts - se	econd check	0.00	1008			Country (43)	<i>D</i>		

Dart Aerospa	ce Ltd
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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Y	es N	o <b>DQ</b> /	<b>A:</b>	_ Date: _	
	R	esolution:	Disposition	n:	_ QA: N/0	Clos	sed:		Date: _	
NCR:		•	WORK ORD	ER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC	In this at	Corrective Action Section		gn &	Verific		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		ate	Secti	on C 	Chief Eng	QC Inspector
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#### Work Order ID 62689

Wednesday, October 06, 2010 3:20:04 PM



Page 2

Item ID:

D4070-041

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Clamp

10/6/2010

**Start Otv: 40.00** Req'd Oty: 40.00

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Reject

Qty

Run

Start

Stop



**Required Date: 10/15/2010** 

OC:

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Tool # Plan

Code

Stop

Reject

Number

Insp.

Stamp

Sequence ID/ Work Center ID

130

Brake NC Brake NC

Operation Description

Form as per dwg

0.00

Sa 10/10/13

Oty

Accept

140

QC

Quality Control

OC5- Inspect part completeness to step on W/O

Memo

Memo

0.00

Jioliol B

courto

150

Small Fab Small Fab

Memo

Assemble rubber cushion as per dwg

0.00

0.00

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Dart Aerospace	Ltd
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W/O:			W	ORK ORDER CHANG	ES			•		
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR:	Yes N	lo <b>DQ</b>	A:	_ Date: _	
	R	esolution:	Dispositi	on:	_ QA: N	/C Clo	sed:		Date:	
NCR:		V	VORK ORI	DER NON-CONFORMA	NCE (	NCR)	)			
DATE	STEP	Description of NC		Corrective Action Section			Verification		Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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#### Work Order ID 62689

Wednesday, October 06, 2010 3:20:04 PM



Page 3

Item ID:

D4070-041

Accept

Setup Start

Stop



Revision ID:

**Start Date:** 

Item Name: Clamp

**Required Date:** 10/15/2010

10/6/2010

**Start Oty: 40.00** 

Req'd Qty: 40.00

**Cust Item ID:** 

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Memo

Memo

Set Up/ **Run Hours** 

0.00

0.00 Stolio114

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

170 Packaging

Packaging

St460

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	gory:	_ NCR: \	es N	lo <b>DQ</b>	<b>\</b> ;	Date:	
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	ICR)				
DATE	OTED	Description of NC		Corrective Action Secti			Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	n Sign & Date		Section C		Chief Eng	QC Inspector
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## **Picklist Print**

Wednesday, October 06, 2010 3:20:09 PM

Work Order ID: 62689

Parent Item:

D4070-041

Parent Item Name: Clamp



**Start Date:** 10/6/2010

**Required Date:** 10/15/2010

Page 1

**Start Qty: 40.00** 

Required Qty: 40.00

Comments:

IPP rev A 10.02.16 new issue EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seg ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B  Rubber Cushion		Manufactured	No				f	191.9952	0.15	6.315789			
				Location		Loc (	<u>)ty</u>	Loc Code			÷		
•				ST402A			7.27		_				
					30872	1	3.67		_				1 . [
					39986		9.1					\ -	114(
					45405		4.5		_		S	10/10	1. /
				ST410		164.72	:524		_		•		
					52649	164.72	.524		_	7			
Cut qty 1 at 1.80" long												•	
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	70.6100	0.019		,9 10-10	-7	
				Location	!	Loc C	<u>Oty</u>	Loc Code					
				MAT		6	4.77		_		/	<b>A</b>	
•					111323		0		_		/(	18	
					115688	6	4.77		_	115688		` }	
				MAT20			5.84		_			ノ	
					115440		5.84		_				

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W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
	R	esolution:	Disposition	<b>:</b>	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	NCE (NCF	1)	· · · · · · · · · · · · · · · · · · ·		
DATE	OTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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DART AEROSPACE LTD	Work Order:	62689
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Description: Clamp	Part Number:	D4070-1
Inspection Dwg: D4070 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	e	Prototype

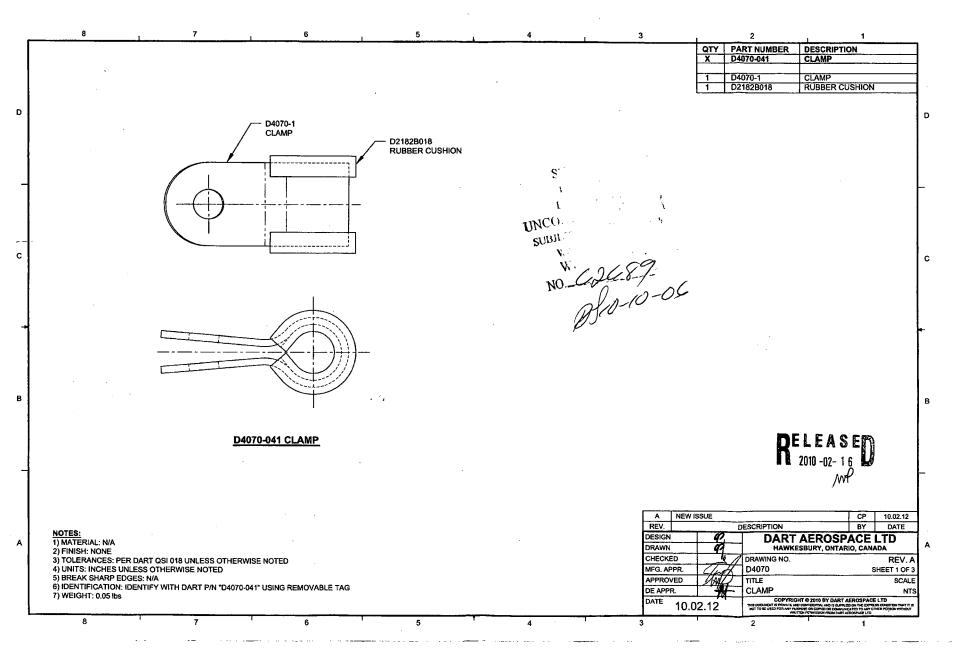
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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0.375	+/-0.010	377	F		V	
0.750	+/-0.010	1751	**		V.	
0.375	+/-0.010	375	b		V	
2.903	+/-0.010	109,6	4		V	
3.653	+/-0.010	3,654	<b>X</b> C		ý	
0.063	+/-0.010	120.	X		V	
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Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	10-10-7	Date: 10/0/08	Date:	N/A

Rev	Date	Change	Revise	ed∧	by	Approved
Α	10.02.18	New Issue	KJ	火	_	<b>M</b>
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W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Resolution:		Disposition: G			A: N/C Closed: Date:					
NCR:		\	WORK ORE	DER NON-CONFORM	MANCE (	NCR)				
DATE	STEP	Description of NC Section A	Initial	Action Description	Section B n Sign &		Verification Section C		Approval Chief Eng	Approval QC Inspector
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W/O:			WORK ORDER CHANGES									
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Part No	):		PAR #:	Fault Category: _		NCR:	: Yes	No DQ	<b>A</b> :	_ Date: _		
	Re	esolution:		Disposition:		ΩΔ- Ι	N/C C	losed:		Date:		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE		Description of NC		Corrective Action Section B	Verification	A					
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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1.64 REF -D wlo 42689 0.750 REF R0.25 2 PL R0.25 10\*\*5\* 0.100±0.050 -В <u>D4070-1 CLAMP</u> (MAKE FROM D4070-1F)

NOTES:
1) MATERIAL: MAKE FROM D4070-1F
2) FINISH: POWDER COAT "BLACK SANDTEX" (4,3,5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: NONE

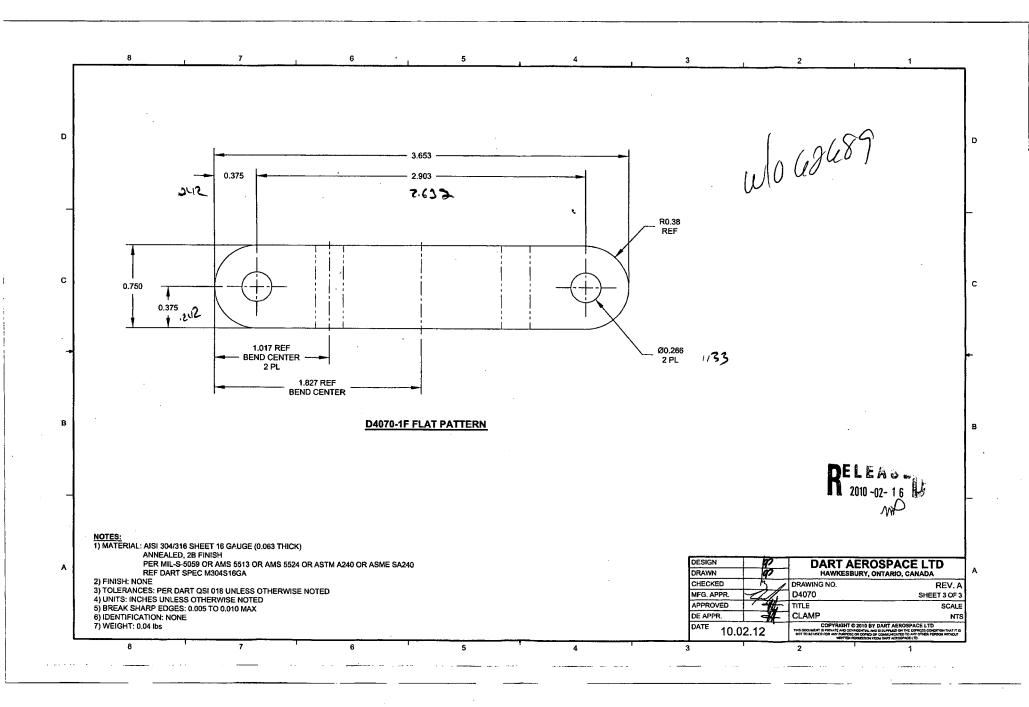
6) IDENTIFICATION: NONE

7) WEIGHT: 0.04 lbs

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A D4070 MFG. APPR. SHEET 2 OF 3 APPROVED TITLE SCALE DE APPR. CLAMP DATE 10.02.12 COPYRIGHT © 2010 BY DART AEROSPACE LTD

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Resolution:					QA: N/C Closed: Date:				
NCR:	·	1	WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			
D.4.T.E		Description of NC Section A	Corrective Action		Section B		cation	Approval	Approval
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
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Resolution:			Dispositio	QA:	QA: N/C Closed: Date:					
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		Description of NC	Corrective Action Section				Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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